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D2803-042
Job Sheet 213384



Part No: D2803-042

Job Qty: 2 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/24/20

Job Tracking No:

Due Date: 10/12/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV C IPP F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM IPP REV:G 16.06.23 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	10/10/20		0.00	0.17	Small Fab - 1		DAS 53 29 OCT 13 2020
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
							Small Fab - Various 1		
110	QC 5	2 pcs	10/10/20		0.00	0.00	QC 5 - 10		DAS 81 9-89 OCT 15 2020
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		

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120 Powdercoat - 1 White GI(A)- B4B <i>M 254469.</i> <i>START: 2:30</i> <i>O.V.T. 300°</i> <i>FINISH: 3:00</i>	2 pcs	10/10/20	0.00 0.16	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	<i>20-10-15</i>
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
130 QC 3	2 pcs	10/10/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	DAS 81
				QC 3 - 82	9-89
				QC 3 - 87	
				QC 3 - 47	
					DAS 58 OCT 16 2020
					9-89
150 Small Fab - 2 - B4B	2 pcs	10/12/20	0.00 0.17	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
160 QC 5	2 pcs	10/12/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	

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				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	DAS
				QC 5 - 40	OCT 19 2020 40
				QC 5 - 61	9-89
				QC 5 - 81	
				QC 5 - 82	
170 Packaging 3-1 - Stock - B4B	2 pcs	10/12/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	DAS
				Packaging 3 - 4 - B4B	28
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	OCT 19 2020
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	2 pcs	10/12/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	OCT 19 2020 DAS
				QC 21 - SA - 77	70
				QC 21 - SA - 28	9-89

Part Op 100 - (Small Fab) Press D2805-2 and D2809 into arm as per Dwg D2803
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 130 - QC3- Inspect Part Finish
 150 - (Small Fab) Assemble as per Dwg D2803.
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2803-2	Bracket 473	2 pcs (1 ea)	100-Small Fab - 1	5160784
D2805-2	Stop 6116	2 pcs (1 ea)	100-Small Fab - 1	5157197
D2809	Washer 6A127	2 pcs (1 ea)	100-Small Fab - 1	5146009
AN3C16A	Bolt 5T348	4 Ea (2 ea)	150-Small Fab - 2 - B4B	6142498
D3672-15	Phenolic Washer 047	8 pcs (4 ea)	150-Small Fab - 2 - B4B	5155086
MS21043-3	Nut 302	4 Ea (2 ea)	150-Small Fab - 2 - B4B	5301320

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	D2803-2	2	6	0
	D2805-2	2	18	0
	D2809	2	16	0
150-Small Fab - 2 - B4B	AN3C16A	4	37	0
	D3672-15	8	275	0
	MS21043-3	4	838	0

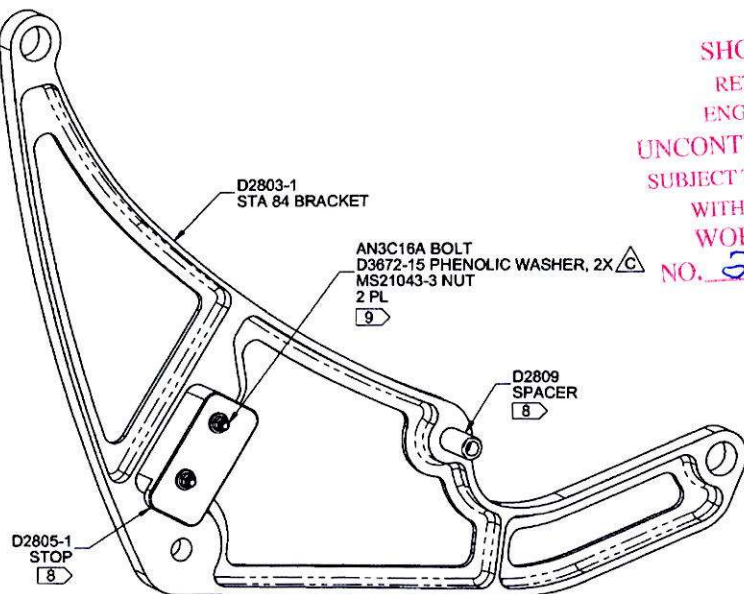
Part Specifications	
Specifications could not be found.	

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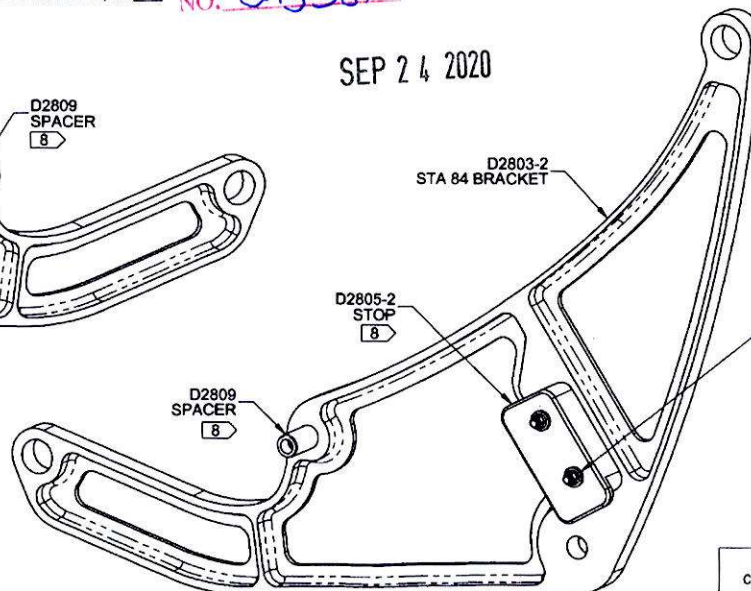
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 213384

SEP 24 2020

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D2803-041	BRACKET ASSY
		X	D2803-042	BRACKET ASSY
1	1		D2803-1	STA 84 BRACKET
2		1	D2803-2	STA 84 BRACKET
3	1		D2805-1	STOP
4		1	D2805-2	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING



D2803-041 BRACKET ASSY



D2803-042 BRACKET ASSY

RELEASED

2016 JUN 22
ECN 16-661

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDEXT" (4.3.5.6) OR "BLACK SANDEXT" (4.3.5.7) OR "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 1.58 lbs
 - 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
 - 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

C	REVISE TO CURRENT FORMAT: ADD DETAILS A AND F AND SECTION E-E; D3672-15 WAS NAS1515H3. ZONES C3-3/C6-4 AND B3-3/B6-3: 2.856 WAS 2.654 AND 0.438 WAS 0.437; REASON: CAD ERROR.	MB	16.04.11
B	ADD CUTOUPS AND -043/-044	CP	04.11.22
A	NEW ISSUE	CP	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D2803	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 84 BRACKET	NTS
DATE	16.04.11	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S306088



Part: D2803-042

Job No: 213384

Serial No/Batch: S306088

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/13/20

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